

Cylindrical Thread Rolling Die

A21-010











HSS Cylindrical Thread Rolling
Die production with CBN and
conventional wheel.

Wheel No. 1 CBN with three
profiles on.

Wheel No. 2 is conventional
wheel with single profile.



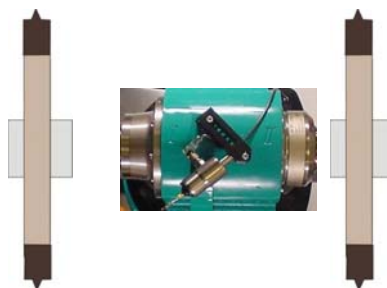
1. Cycletime for Production

Workpiece: Ø178 L76 Z310 P1.805 Helix 21° Material HSS					
Operations					
	MainThread	Dress	MainThread	Dress	MainThread
Feed [mm/Min]	250	36	2000	36	2000
Increments [tot./part.]	0.02/0.02	0.1/0.01	0.03/0.01	0.05/0.01	0.02/0.005
Cutting speed [m/s]	45	12	45	12	45
Used wheels					
	1	2	2	2	2
Grinding time [s]	1941	800	1378	400	1837
Total cycle time	105 Min 56				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø200 B106
2	DXF Ø200 C220



1

2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMAcfgr

Control: Fanuc 31i

Accessories: Dressing Unit

Responsible engineer: OP, 25.5.13

Coolant: Synthetic Oil, pressure 10 bar

Software: Quinto 5

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Germany, Italy, United States, China